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U/R SAD
19/07/13

D4842-041
Job Sheet 198838



POSITIVE RECALL

Part No: D4842-041

Job Qty: 4 pcs

EFFECTIVE 19/07/13 AUTH SAD

Part Name: Lower Cutter Assembly



RELEASED [Signature] DATE 20-04-06.

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Concession Required

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 16-692 DWG REV B U/R IPP REV:A 13.04.30 NEW ISSUE DD VERF:JLM IPP REV:B 13.11.01 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	4 pcs		10/21/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		



Container No: S246942



Part: D4842-041

Job No: 198838

Serial No/Batch: S246942

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Date: 01/13/20

DAS
41 JAN 13 2020
9-89

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					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
170 Small Fab - 2 - B4B	4 pcs	10/21/19	0.00 9.09	Small Fab - 1 - B4B		
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B		
				Small Fab - 6 - B4B	DAS 41 JAN 13 2020	
				Small Fab - 7 - B4B	9-89	
				Small Fab - 8 - B4B		
180 QC 5	4 pcs	10/21/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40	DAS 40 JAN 14 2020	
				QC 5 - 61	9-89	
				QC 5 - 81		
				190 Packaging 3-1 - Stock - B4B	4 pcs	10/21/19
Packaging 3 - 2 - B4B						
Packaging 3 - 3 - B4B	DAS 74 9-89					
Packaging 3 - 4 - B4B						
Packaging 3 - 5 - B4B						
Packaging 3 - 6 - B4B						
Packaging 3 - 7 - B4B						
Packaging 3 - 8 - B4B						
Packaging 3 - 9 - B4B						
Packaging 3 - 10 - B4B						
Packaging 3 - 11 - B4B						
Packaging 3 - 12 - B4B						
Packaging 3 - 13 - B4B						
Packaging 3 - 14 - B4B						
Packaging 3 - 15 - B4B						
Packaging 3 - 16 - B4B						
Packaging 3 - 17 - B4B						
Packaging 3 - 18 - B4B						
Packaging 3 - 19 - B4B						
Packaging 3 - 20 - B4B						
Packaging 3 - 21 - B4B						
Packaging 3 - 22 - B4B						
Packaging 3 - 23 - B4B						
Packaging 3 - 24 - B4B						
Packaging 3 - 25 - B4B						
Packaging 3 - 26 - B4B						
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					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	
					QC 21 - SA - 70	
200	QC 21 - SA	4 pcs	10/21/19	0.00 0.00	QC 21 - SA - 53	

MAR 09 2020

Part Op 100 - (Pick Kit)

Descriptions: 170 - Assemble as per dwg and apply loctite 598 on all faying surfaces. 5233475 exp 2/21

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Identify as per dwg & Stock Location: _____) CONCESSION

200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4839-1	Blade	8 pcs (2 ea)	100-Packaging 1 - Pick Kit	5239365 5229447
D4842-1	Lower Cutter Deflector	4 pcs (1 ea)	100-Packaging 1 - Pick Kit	5206348(2) 5155267(2)
D4842-3	Lower Cutter Body, LH	4 pcs (1 ea)	100-Packaging 1 - Pick Kit	5220950
D4842-4	Lower Cutter Body, RH	4 pcs (1 ea)	100-Packaging 1 - Pick Kit	5221344
MS21042L08	Nut	24 Ea (6 ea)	100-Packaging 1 - Pick Kit	5231236
MS27039-08-19	Screw	24 Ea (6 ea)	100-Packaging 1 - Pick Kit	5231293
NAS1149FN832P	Washer (AN960-8)	48 Ea (12 ea)	100-Packaging 1 - Pick Kit	5235228

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	D4839-1	8	13	0
	D4842-1	4	10	0
	D4842-3	4	8	0
	D4842-4	4	10	0
	MS21042L08	24	611	0
	MS27039-08-19	24	421	0
	NAS1149FN832P	48	1,756	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: <u>198838</u> Part No. <u>D4842-041</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐							
Date :		Sequence #:		QTY Affected :		MRR (QSI042) 51 9-89 <i>19/08/13</i>			
Description Work Order Deviation <i>*Use 3 bolts with plastic washers and Nuts at the base of the cable cutter (Fuel/Mid/Aft) to secure all Parts together for the curing time.</i> <i>*Make sure Bolts are snug for the curing time period.</i> <i>*Remove bolts/washer/nuts after cure time before heading to QC</i>				Disposition <i>employee was inform how to do the assembly.</i>				Completed By DAS 41 9-89 <i>JAN 13 2020</i> Lead hand / Supervisor DAS 9 9-89 <i>20-01-13</i> QC / QA Coordinator DAS 9 9-89 <i>20-01-13</i>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
		Other/Details:							